

**Work Order ID 85106**

Friday, June 01, 2012 4:04:36 PM

**\*85106\***

Page 1

Item ID: PB67-43001-23

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: PB67-43001-23

Start Date: 6/1/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

*MF*

Date:

*12-06-11*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-23

Rev C

100

0.00

**\*100\***

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg PB67-43001

*2**Ø**Le  
12.06.20*

110

0.00

**\*110\***

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*Schulze**2*

120

0.00

**\*120\***Identify as per dwg & Stock Location: *437*

Packaging

Memo

0.00

Packaging

*Pf/20 2*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 85106****\*85106\***

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Friday, June 01, 2012 4:04:36 PM

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Revision ID:

Stop **\*NS2\***

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Start Date: 6/1/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 6/29/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC21- Final Inspection - Work Order Release

0.00


**\*130\***

QC

Memo

0.00

Quality Control

12/6/21 

D1206-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 1  
*[Signature]*

Work Order ID: 85106

Parent Item: PB67-43001-23

Start Date: 6/1/2012

Required Date: 6/29/2012

Parent Item Name: PB67-43001-23

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-25 new issue DD verified by:ec  
dwg EC verified by:DD  
IPP Rev B 10.09.28 per rev C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-10 Screw		Purchased	No			100	Each	126.0000	8	16	<i>[Signature]</i>	12.06.20	

Location	Loc Qty	Loc Code
GA <u>122027</u>	100	
120449	100	
ST291	26	
<u>120120</u>	26	

* NAS1149D0316J / AN9605010LL Washer	Purchased	No		<u>B19600 = 16</u>	100	Each	0.0000	8	16	<i>[Signature]</i>	12.06.20	
NAS1149D0363J Washer	Purchased	No			100	Each	2,183.0000	12	24	<i>[Signature]</i>	12.06.20	

Location	Loc Qty	Loc Code
ST298	2183	
117601	61	
118077	1	
118612	18	
119537	33	
120142	13	
120308	17	
120644	86	
121243	494	
<u>121524</u>	1460	

PB67-43001-181 Cover Plate	Manufactured	No			100	Each	11.0000	1	2	<i>[Signature]</i>	12.06.20	
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Location	Loc Qty	Loc Code
ST443	11	
<u>53336</u>	11	

* PB67-43001-79 Lower Blade Support Assembly	Manufactured	No		<u>B35117 = 2</u>	100	Each	0.0000	1	2	<i>[Signature]</i>	12.06.20	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 01, 2012 4:04:36 PM

Page 2

Work Order ID: 85106  
Parent Item: PB67-43001-23  
Parent Item Name: PB67-43001-23

Start Date: 6/1/2012  
Start Qty: 2.00  
Required Date: 6/29/2012  
Required Qty: 2.00

\ ~~1~~ PB67-43001-83 Manufactured No 100 Each 11.0000 1 2  
PB67-43001-83  
Location Loc Qty Loc Code  
ST444 11  
53240 11 2  
Ae 12.06.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

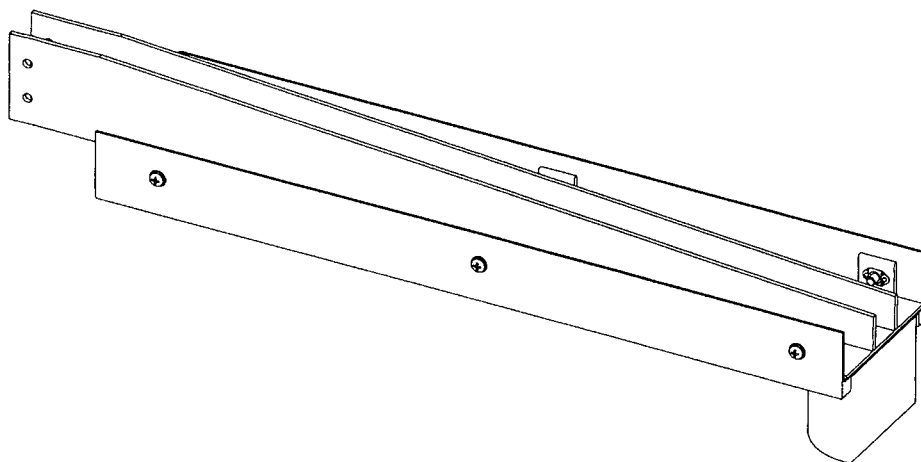
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**B67-43001-23 LOWER BLADE SUPPORT AND COVER ASSY**

ITEM	QTY -23	P/N	DESCRIPTION
1	X	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
3	1	B67-43001-79	LOWER BLADE SUPPORT ASSY
4	1	B67-43001-83	D-PAD ASSEMBLY, SHORT
5	1	B67-43001-181	COVER PLATE
7	8	MS27039-1-10	SCREW
8	8	NAS1149D0316J	WASHER
9	12	NAS1149D0363J	WASHER

#85106

**RELEASED**  
2010-09-16

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 10 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.07.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	[Signature]			
CHECKED	[Signature]	DRAWING NO.	REV. C	
MFG. APPR.	[Signature]	B67-43001-23	SHEET 1 OF 2	
APPROVED	[Signature]	TITLE	SCALE	
DE APPR.	N/A	LOWER BLADE SUPPORT AND COVER ASSY	NTS	
DATE	09.07.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

**Dart Aerospace Ltd**

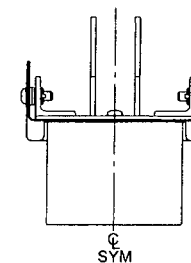
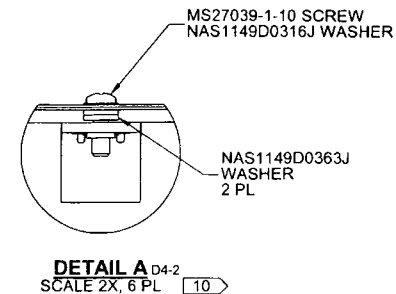
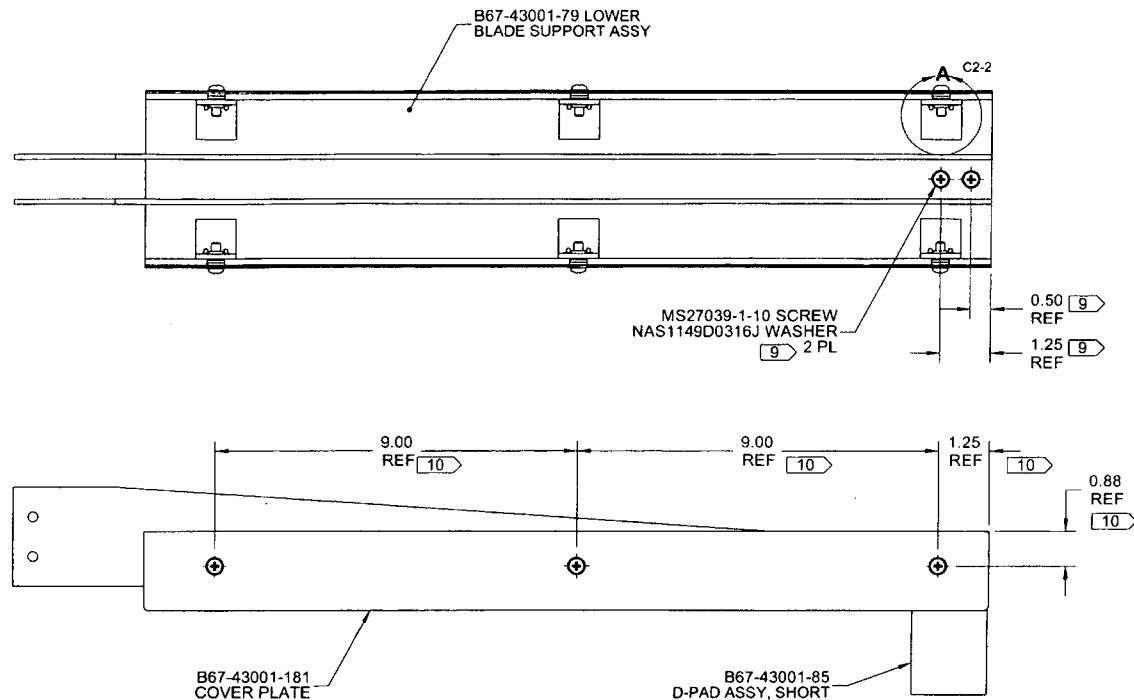
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# **B67-43001-23 LOWER BLADE SUPPORT AND COVER ASSY**

## **NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.10 lbs
- 8) WELDING: PER DART QSI 004
- 9) MATCH DRILL  $\varnothing 0.250$  THRU B67-43001-181 WITH HOLE PATTERN OF B67-43001-79
- 10) MATCH DRILL  $\varnothing 0.250$  THRU B67-43001-181 WITH HOLES IN ANGLE BRACKETS ON B67-43001-79

DESIGN	RW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>B67-43001-23</b>	REV. C
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		LOWER BLADE SUPPORT AND COVER ASSY	SCALE NTS
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
DATE	09.07.28	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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